

Work Order ID 60205-2 split *AM*
Monday, June 28, 2010 3:24:28 PM



Page 1

Item ID: D3405-043

Accept



Setup Start



Revision ID:

(10)

Stop



Item Name: Lug Assembly

Start Date: 6/28/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10629

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

1B 10-7-1

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

=> Deburr m.p. w/07/05

(15X)

(15)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1B 10-7-1

Quality Control

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Sector

(15)

Quality Control

Work Order ID 60205

Monday, June 28, 2010 3:24:28 PM



Page 2

Item ID: D3405-043

Accept

Revision ID:

Item Name: Lug Assembly

Start Date: 6/28/2010 Start Qty: 8.00

Required Date: 7/5/2010 Req'd Qty: 8.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

0.00

Memo

Deburr

Form using DT8204 as per Dwg D3405

SB 12/07/07

(15)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8.10.10.7/07

(15)

150



Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

Weld as per Dwg D3405 use DT8484

Identify as D3405-043

DT 8484

EL

10-10-28

(X10)

Work Order ID 60205

Monday, June 28, 2010 3:24:28 PM



Page 3

Item ID: D3405-043

Accept

Revision ID:

Item Name: Lug Assembly

Start Date: 6/28/2010 Start Qty: 8.00

Required Date: 7/5/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

CP 10-10-29

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/10/29

+10

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115291

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00
400°
12:30

10

10-11-2.

Work Order ID 60205

Tuesday, November 02, 2010 1:19:10 PM



Page 4

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 6/28/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

7/11

10/11/02

10

4

Memo

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location: 114

0.00

Memo

0.00

10/11/2 100%

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Cathy New 10/11/03 MF 10-11-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 28, 2010 3:24:33 PM

Page 1

Work Order ID: 60205

Parent Item: D3405-043

Parent Item Name: Lug Assembly





Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1  GHW Lug		Manufactured	No			100	Each	10.0000	1	8			
<div> <div>B62471 x10</div> <div> <u>Location</u> WA 59691 </div> <div> <u>Loc Qty</u> 10 10 </div> <div> <u>Loc Code</u> </div> </div>													
M304S11GA  304/316 0.125 Sheet		Purchased	No			150	sf	132.4659	0.154	1.296842			
<div> <div></div> <div> <u>Location</u> MAT 114488 114799 </div> <div> <u>Loc Qty</u> 132.4659 4.4659 128 </div> <div> <u>Loc Code</u> </div> </div>													

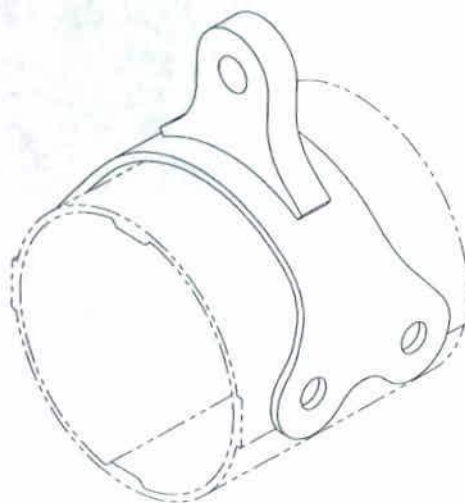
Cpl 10-10-04
 B60858 → (5)
 23
 1810-7-1
 (15)
 114799

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

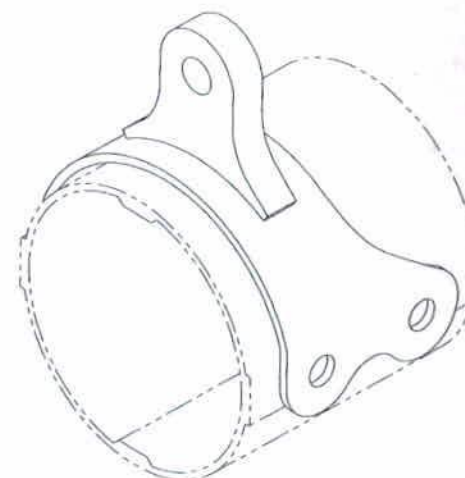
△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60205

PH 10-6-29



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



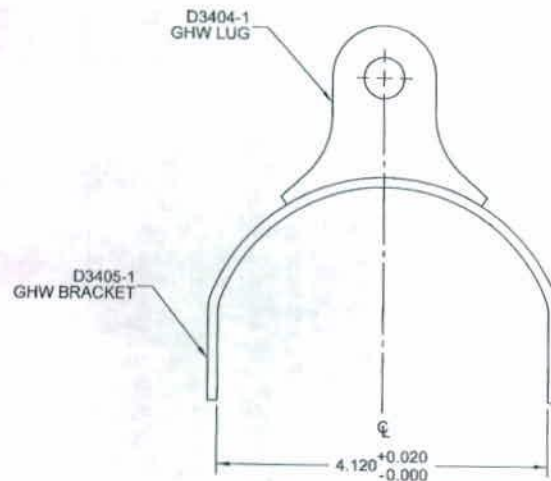
D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

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08/12/18 M.P.

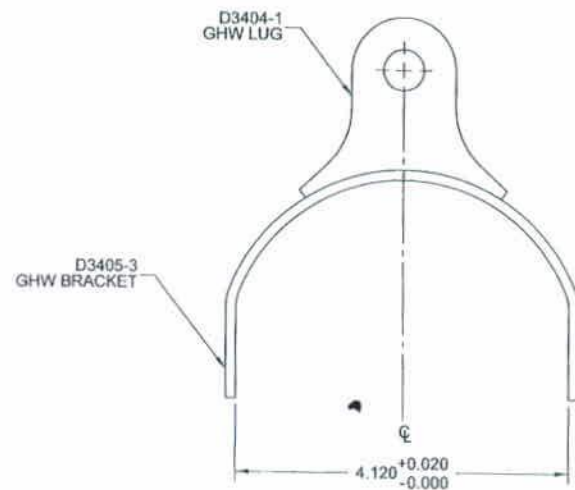
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

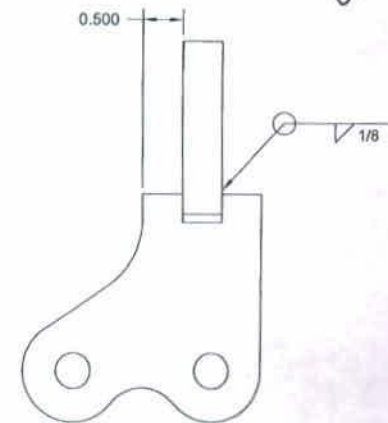
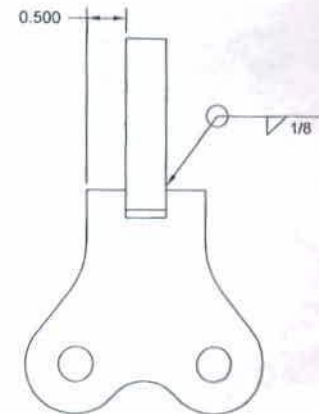
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PART 198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
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D3405-041 LUG ASSEMBLY



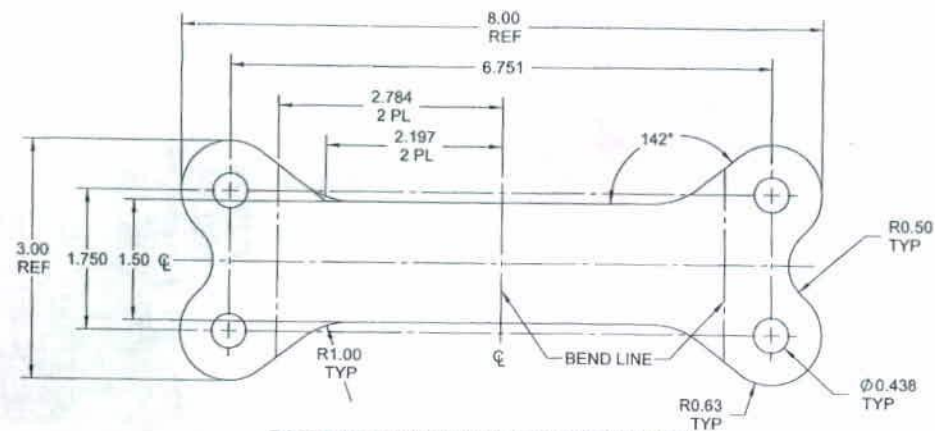
D3405-043 LUG ASSEMBLY



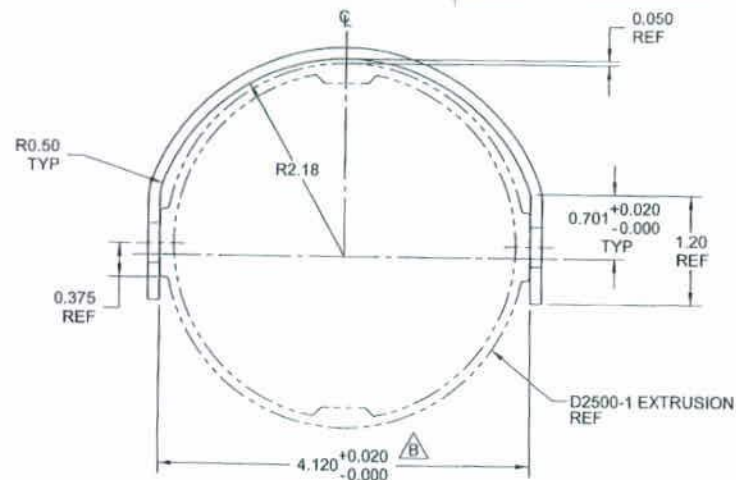
info 60205

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06/12/18

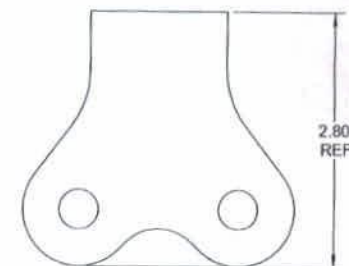
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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

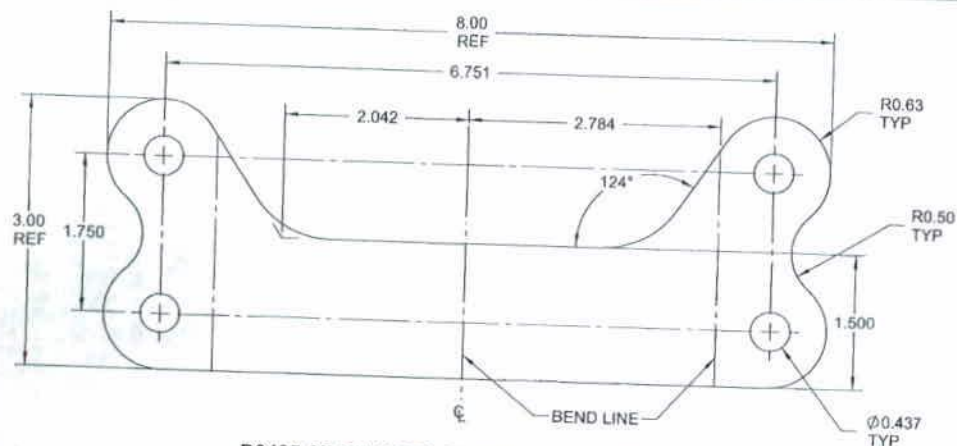
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

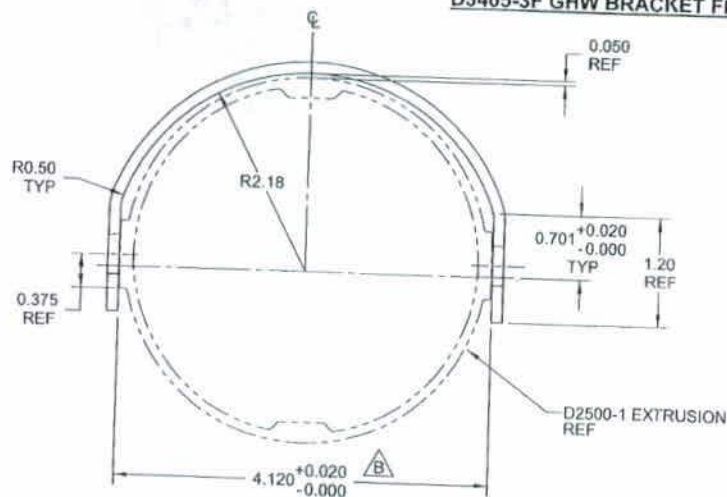
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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
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APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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08/09/19

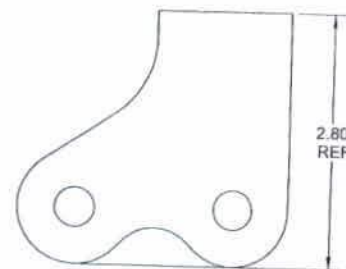
WLO 10205



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
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